












Date: Monday, 22/09/2008 1:03:38 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 42175		
Estimate Number	: 10518		
P.O. Number	:	Part Number	: D28063
This Issue	: 22/09/2008 S.O. No. :	Drawing Number	: D2806 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 39058	Material	:
Written By	:	Due Date	: 29/09/2008 Qty: 50 Um: Each
Checked & Approved By	: <u>JLD 08.9.22</u>		
Comment	: Est:B 05.03.11 Part now turned KJ/JLM Est Rev:C Now on Doosan Lathe JLM Verified By:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6H1000	6061-T6 HexBar 1.00	
			
Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s) 6061-T6 Hex Bar 1.0" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar (M6061T6H1.000) Batch: <u>M 109478 SA 08/11/11</u>			
2.0	DOOSAN LATHE	DOOSAN LATHE	
			
Comment: Doosan Lathe 1- Turn as per Folio FA105 Rev: <u>NA</u> & Dwg D2806 Rev: <u>A</u> 2-Deburr per dwg D2806 <u>SA 08/11/11</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 08/11/11</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>J.L 08/11/11</u>			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>M-J 08/11/12</u> <b>(50X)</b>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BUSHING

Job Number: 42175

Part Number: D28063

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*HL*



Comment: INSPECT ALODINE

08-11-12

*(508)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



*(508)*

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *42*

*8/11/12*

*50*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/13 *df*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08.11.13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

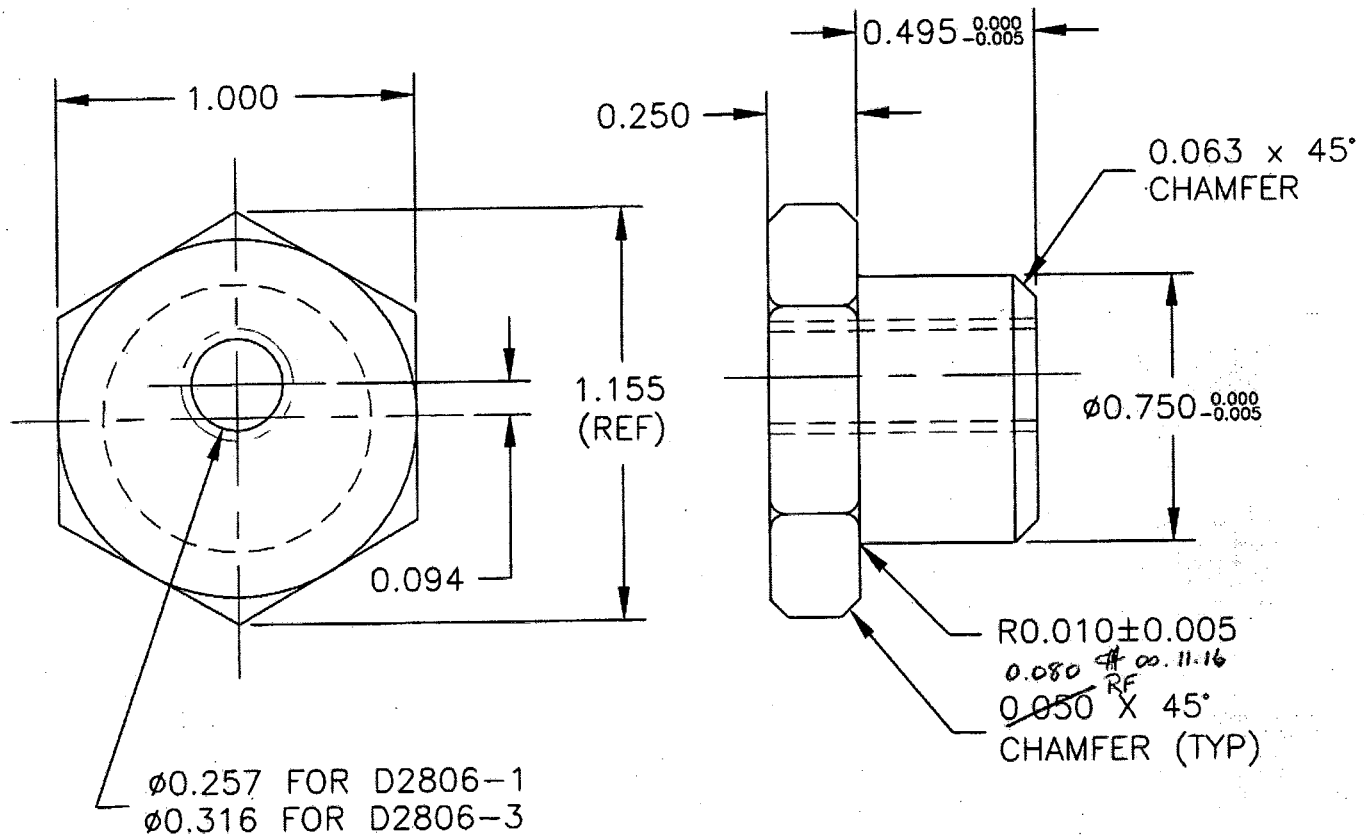
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

**RELEASED**  
00.11.13 #

D2806-1 (DRILL  $\phi 0.257$  HOLE)  
D2806-3 (DRILL  $\phi 0.316$  HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-250/12)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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